

# Work Order ID 72897

Wednesday, August 17, 2011 2:46:50 PM

Page 1

Item ID: D3915-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Light Lid Assembly, Long Basket

Start Date: 8/17/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3915

C

100

Weld per dwg A/R Aluminum rod Batch: 117889 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D3915

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.08.25 1 φ

1 8211/08/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72897

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Item ID: D3915-041

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Setup Start



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Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*5 w/08/26*

*40*

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

\*\*\*ENSURE TO RINSE CAREFULLY ACID AND ALODINE\*\*\*

*1X Ø M-11/08/21*

140



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: *M117889* 0.00

Memo

0.00

1- weld (4) corners

*P11-08-30*

*P10 →*

W/O: 72897		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3915-041 PAR #: N/A Fault Category: Large FAB (welds) NCR: (Yes) No DQA: / Date: 11.09.02  
 Resolution: Good as is acceptable Disposition: Good as is use QA: N/C Closed: / Date: 11/09/02

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/8/30	#110	Found when welding corners that the D4056-1 Label was welded on the wrong side of the L.O.	11.08.30	THIS IS AN ACCEPTABLE DEVIATION. THIS W/O ONLY!	CPC 11.08.30	5 11/08/31	11.08.30	5 11/08/30
	#100	was missed at both dec 915 R.c. back at attention (Drawing is clear) welder on Bottom not top						5 11/08/30

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/08/29

155

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 11/08/31

\*\*\*inspect fit of lid with base\*\*\*

157

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1- realodine corners  
\*\*\*do not acid etch\*\*\*

1X 0 M-11/08/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 8/17/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- touch up corner with alodine only  
2- Plug holes prior to

1ST COAT:

START TIME: 8-50

OVEN TEMPERATURE: 328

FINISH TIME: 9-28

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IX 11/08/31

1 11-8-31

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



HandFinish

Hand Finishing

Assemble as per dwg

0.00

Memo

0.00

1- Install webbing as per dwg

2- Install placard and label as per dwg

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

200



Packaging

Packaging

Identify as per dwg & Stock Location:

G-A

0.00

Memo

0.00

W/O 73282


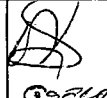

8/31/08/31

(H)

8/31/08/31

W/O: 7287		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3915-041 PAR #: N/A Fault Category: Small Frag NCR: Yes No DQA: NA Date: 11.09.08  
11.8/14 Resolution: Rework Disposition: Rework QA: N/C Closed: ✓ Date: 11/09/08

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/31	190	34 rivets <del>have</del> to be removed as web installed on the wrong side.		Strap rivets + Rivet hole Put Sykalite in each hole and reinstall webbing M118626 2H x34 in these holes.	S/S 11/08/31	S 11/08/31		
		R.C. LOA. operator used Paying Attention to Drawn						

NOTE: Date &amp; initial all entries

**Work Order ID 72897**

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Required Date: 8/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/31

U 11.28.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 1

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement or further action.

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**Required Qty: 1.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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4

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11.08.25

**Loc Code**

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2<sup>a</sup> *RE 11.08.25*

**Loc Code**

4

68554

4

Each



3  
PK 11.08.25

Loc Code

9

66335

6

68544

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 72897

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each

11.0000

3

3



Rib



*11.08.25*

## Location

## Loc Qty

## Loc Code

WA

8

63667

0

68605

8

WA006

3

66726

3

*3*

D4035-045 Manufactured No

100 Each

0.0000

1

1



Lid Rib Assembly, Fwd (Light)



*11.08.25 B72898*

D4035-047 Manufactured No

100 Each

4.0000

1

1



Lid Rib Assembly, Aft (Light)



*11.08.25*

## Location

## Loc Qty

## Loc Code

WA

3

63669

0

68546

1

71225

2

WA006

1

67822

1

*1*

D4056-1 Manufactured No

100 Each

1.0000

1

1



Label Plate



*11.08.25*

## Location

## Loc Qty

## Loc Code

WA005

1

59750

1

*1*

D2728-1 Manufactured No

180 Each

0.0000

1

1



Dart Logo Label



Wednesday, August 17, 2011 2:46:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 72897

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 1.00

Required Qty: 1.00

D4029-041 Manufactured No

180 Each

5.0000

1

1



Webbing (Long Basket)



Sl 46861

Location

Loc Qty

Loc Code

st503

5

68043

1

69499

4

1

MS20600-AD4W3 Purchased No

180 Each

543.0000

34

34



Cherry Rivets



Sl 468131

Location

Loc Qty

Loc Code

ST321

410

111636

48

117505

327

117601

35

WA018

133

107939

133

M118624

34

NAS1149DN416J Purchased No

180 Each

283.0000

34

34



Washer



Sl 468131

Location

Loc Qty

Loc Code

ST298

283

114348

11

114597

187

13910

85

34

M112384

34

Wednesday, August 17, 2011 2:46:57 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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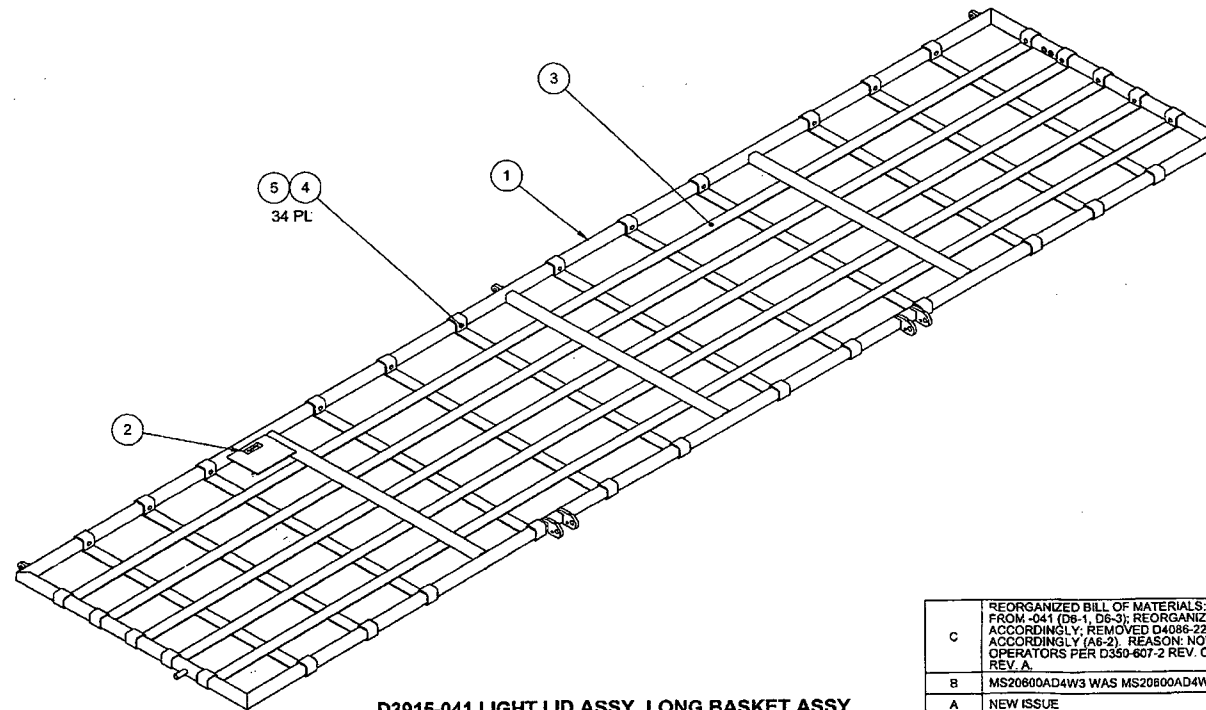
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 7257

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER



**D3915-041 LIGHT LID ASSY, LONG BASKET ASSY**

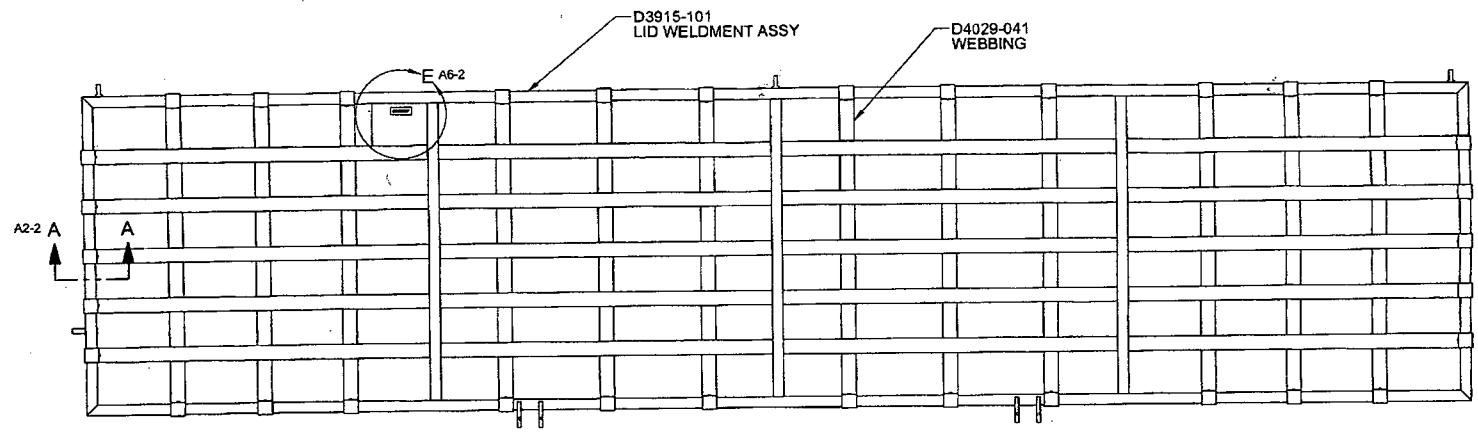
**RELEASED**  
10.08.05  
ECN 10-596

**NOTES:**

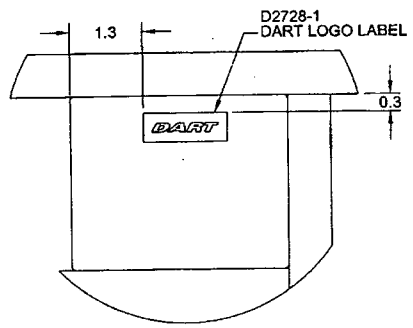
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C	REORGANIZED BILL OF MATERIALS, SEPARATED -101 FROM -041 (D8-1, D8-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20800AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SA	DRAWING NO.	REV. C
MFG. APPR.	SA	D3915	SHEET 1 OF 4
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

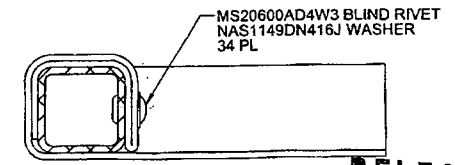
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**D3915-041 LIGHT LID ASSY. LONG BASKET**



**VIEW E** DS-2



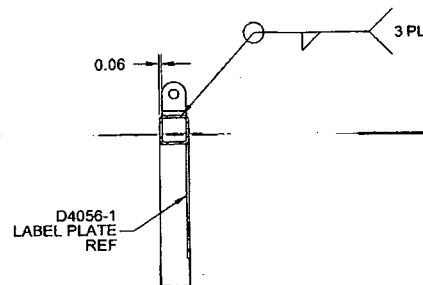
**SECTION A-A** C8-2

**RELEASED**  
10.08.05

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SE	DRAWING NO. <b>D3915</b>	REV. C
MFG. APPR.	SE	SHEET 2 OF 4	
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	<b>LIGHT LID ASSY-LONG BASKET</b> NTS	
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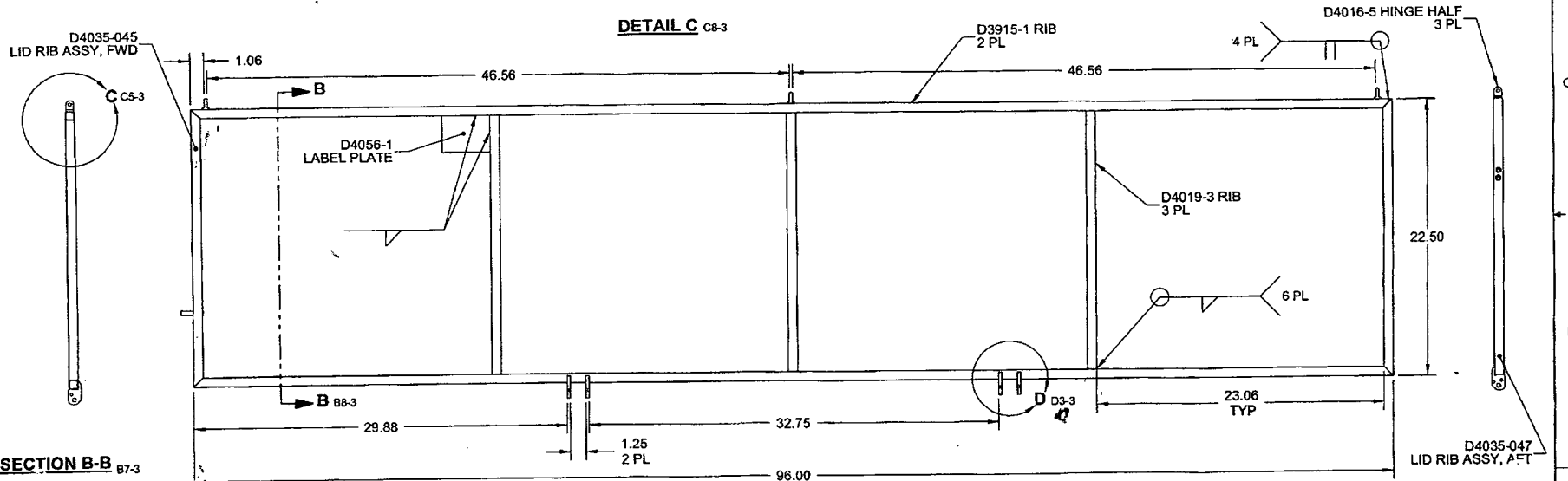
72897

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



**DETAIL D** B3-3  
D2957 MOUNTING PLATE  
4 PL

**DETAIL C** C8-3



**SECTION B-B** B7-3

**D3915-101 BASKET LID WELDMENT ASSY**

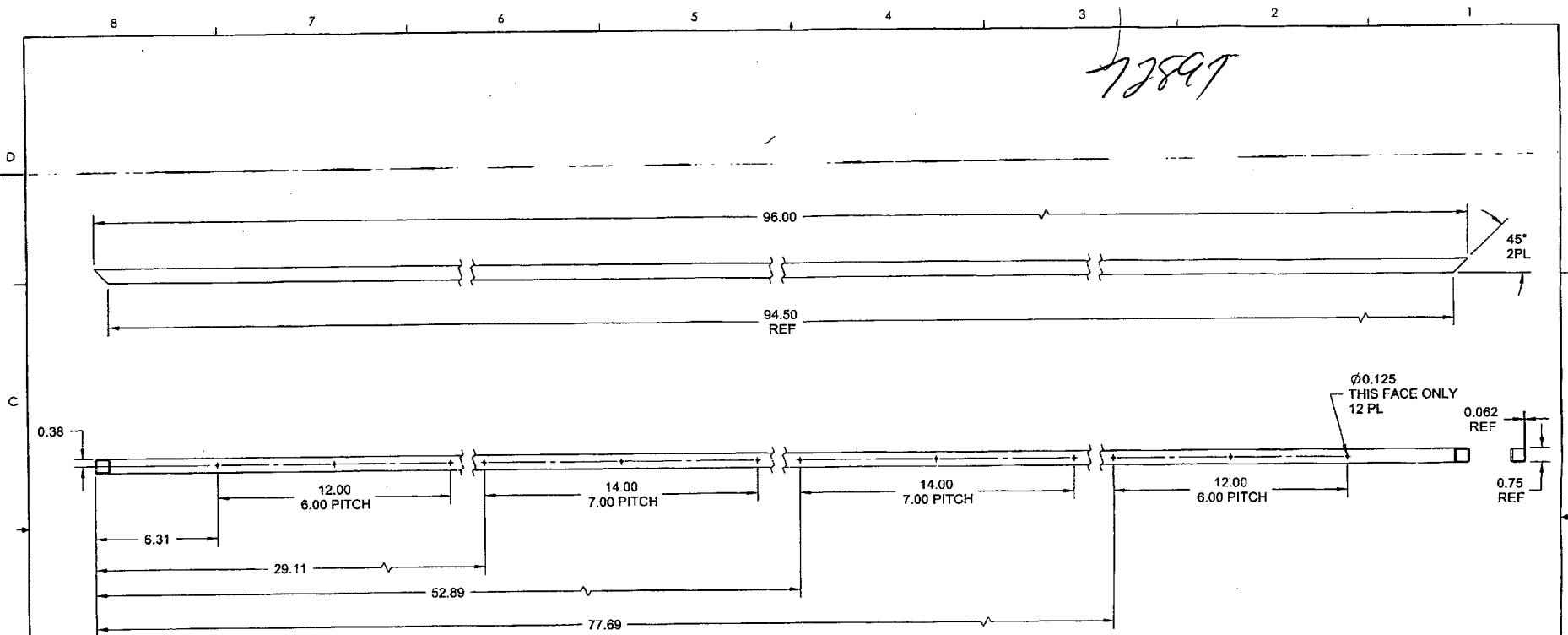
**RELEASED**  
10.08.05

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3915	REV. C
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>LIGHT LID ASSY-LONG BASKET</b>	NTS
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**D3915-1 RIB**

**RELEASED**  
(10-01-12 CP)

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.49 lbs

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKETNTS	
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